

Date: Monday, 11/12/2007 10:51:37 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP EXTRUSION
Job Number : 35618	
Estimate Number : 10058	
P.O. Number : <i>N/A</i>	Part Number : D2622120C
This Issue : 11/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2622 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : C1
Previous Run : 34694	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/30/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>132</i> Um: 110 Each
Comment : Est. A: 02.11.12 New Issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: *5013**CL07/10/12*

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" long) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

(110) 121

2.0	D2622120CP	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)
 Extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

*CL 7/11/12 B**(132)*

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimension per Dwg D2622
 Check Pull test per Dwg D2622 for compliance page attached
 Check hardness with Webster tester

CL 4/11/12 7 (132)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 07/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP EXTRUSION

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FL/BF 07/11/29 (132)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(132)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/30

Job Completion



07.11.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

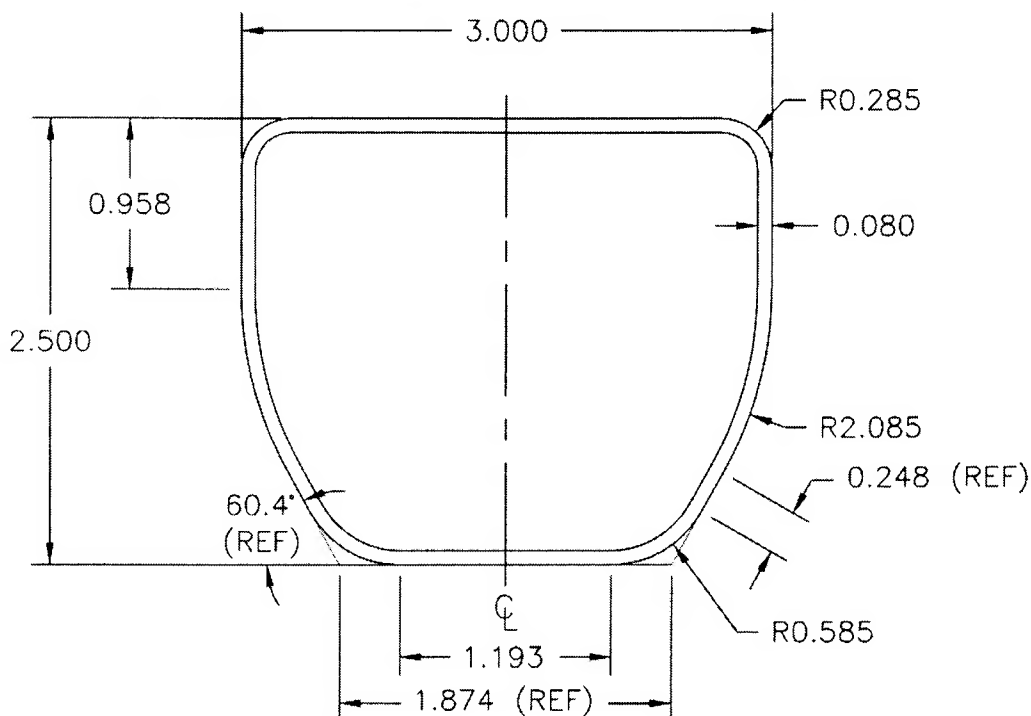
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
C1	GP 02.10.04	ADD 'REV-A' TO DIE NUMBER	

RELEASED
02.09.11 H



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W10: 35648

C207/10/10



BON L CANADA INC.

ADCT# 00046024

INVOICING COMPANY AND LOCATION
BUREAU DE FACTURATION

GON L CANADA INC
500 EDWARD AVENUE
RICHMOND HIL ON

443 449

**SHIPPING MANIFEST
BORDEREAU D'EXPEDITION**

MANIFEST DATE/DATE D'EXPÉDITION
11-23-07

MANIFEST NUMBER/N° D'EXPÉDITION	421253
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SALES ORDER NUMBER/N° DE COMM.
14251

**REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.**

CREDIT REP/REP. DU CRÉDIT
HARBORC, PAU
905-508-5250

SALES REP/REP. DES VENTES

LOC/USINE

TRAILER NO./N° DE REMORQUE

SALESMAN/VENDEUR

FIELD SALES REP/REP. RÉGIONAL DES VENTES

S	CLUST SERVICE REP/REP SERVICE CLIENTÈLE
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PHONE 613-632-5200

PHONE 613-632-5200

1990

52525

59239

Letter A

Burlon D

CLIENT ID/N° DU CLIENT
46024

ORDER DATE
DATE DE LA COMMANDE
11/12/97

CUST. P.O. NO./N° DE COMM. DU CLIENT
5013

JOB/PROJET	
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	BILL OF LADING NUMBER/N° DE CONNAISSEMENT
	00345098

450-425-6551

905-427-2227

ITEM NO.	ORDER QUANTITY QTE COMMANDEE	UNIT UNITE	PREVIOUS SHIPPED QTY. QTE DEJA EXPEDIEE	MFG. PART NUMBER N° DE PIÈCE DU FOURNISSEUR	ALLOY & TEMPER ALLIAGE & TREMPÉ	FINISH DESCRIPTION DESC. DE LA FINITION	THIS SHIPMENT/CETTE EXPÉDITION			UNIT UNITE	QUANTITY DUE QUANTITÉ PRÉVU
				CUSTOMER PART NUMBER NUMÉRO DE PIÈCE DU CLIENT	CUTTING TOLERANCE TOLÉRANCE DE COUPE	FABRICATION DESCRIPTION TYPE DE FABRICATION	NO. PKGS. N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET		
01	121	KG M PC	0 0 C	06A-897123-1 02622	5061 / T6 120" +3/16 " -0 "	MILL CERTIFICATE OF COMP (-015-015,0139-0102)	2	571	547 402.34 122	KG M PC	C C C
				DETAIL: LOT/TICKET		142S1010 / 181102 142S1010 / 181103	1 1	298 272	286 261		1 69 PC 69 PC <u>132</u>
							TOTAL/TOTAUX				

CRM NO. B1065 REV.D
O RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION
UCUN RETOUR DE MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

**CUSTOMER
CLIENT**

PAGE 1



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Card Date	Card No	Sales Order	Page
11/23/07	169640	14251	1
Cust PO	B/L No	Lot	Date
5013	00365098	14251010	11/23/07

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	571 KGS
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Net Qty	547 KG	132 PC	402 M	2 PKG
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Specification	Die Desc
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AMS-QQ-A-200/8 & ASTM B221-00	
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Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	307.6 / 44.6	277.3 / 40.2	10.5	.0	96

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.24	.28	.07	.92	.07	.006	.06	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada